

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028096**Date Inspected:** 02-Aug-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** As noted below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

Electroslag Weld Excavation / Repair

This QA observed, at random intervals, ABF/JV welding personnel Xiao Jian Wan #9677 performing excavation of an Electroslag Weld (ESW) previously Ultrasonic Tested (UT) by Quality Control (QC) technicians.

The UT discovered indication was found to be oriented in the longitudinal position. The indication was found to be rejectable per AWS D1.5 Table 6.4).

The weld being excavated is designated as "ESW Q" and was excavated on Face B at location:

Weld "Q" - Excavation is in-process. Final measurements have not been taken.

Please see attached photographs indication discovered during excavation.

This QA observed, at random intervals, ABF/JV qualified welder James Zhen #6001 continue performing Flux Core Arc Welding (FCAW) implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-3000-3Repair. The joint being welded was tower shear plate designated as ESW weld, location "Q" from face B.

Weld "Q" - Y= 6450mm, L= 950mm, W= 90mm, D= 53mm

During welding, ABF Quality Control (QC) Bernard Docena was noted monitoring the welding parameters.

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Conversations were relevant to work performed.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Clifford, William
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Quality Assurance Inspector

Reviewed By:	Levell, Bill
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QA Reviewer
